shift at the time it is tightened, although when once tightened it will remain in position.

In Fig. 18 a different arrangement is shown. Here the thumb-screw and spring plunger used in the preceding device is abandoned, and the sliding wedge *A* is used to obtain the pressure upon plunger *C.* The wedge is provided with a handle *B* attached so that it can easily be operated, and is held in place by two shoulder screws that are inserted through two elongated slots milled in the wedge. These screws are tightened after the stop has been brought up to position. The difficulty met with in using this stop is that the wedge is liable to slip back, owing to

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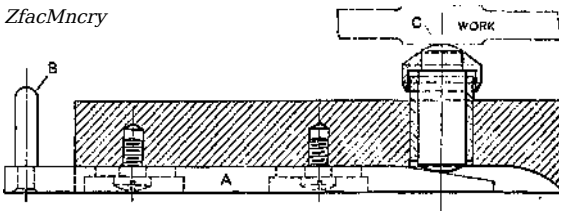

Fig. 18. Simple Form of Adjustable Wedge Stop

the vibration of the machine while in operation, so that plunger *C* drops down.

In Fig. 19 is shown a further development of the method indicated in Fig. 18. In this case, means are provided for preventing wedge *A* from slipping back. A stud is riveted into the wedge *A,* this stud extending up through an elongated slot cut in the base of the fixture. The end of the stud is threaded for the knurled nut 5, which also acts as a handle for shifting the

wedge. When this nut is tightened, it clamps the wedge *A* and the shoe C against the base. The friction between shoe *C* < and the base prevents the slipping of wedge *A.* Shoe *C* also acts as a covering for the slot cut in the base, and thus acts as a dirt and chip shield. It is prevented from turning, when the nut *B* is tightened or loosened, by a stud D, driven into it and sliding in a slot cut in the base. The difficulty with this design is that wedge *A* rests upon the table of the machine, and, if there is slight unevenness in the table, the plunger is liable to spring down slightly under the pressure of the cut.